



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D3601-1  
Job Sheet 204307



Part No: D3601-1

Part Name: Radius Block



Part Weight: 0 lbs

Job Created: 12/6/19

Due Date: 1/10/20

Type: SOLD

Note: DWG REV A IPP Rev:A New Issue 07-03-28 JLM

Ship Via:

Job Qty: 200 pcs

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Bill of Materials

Job Routing

| Op No | Operation   | Qty     | Start Date | Due Date | Standard Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time | Sign-off |
|-------|-------------|---------|------------|----------|--------------------|---------|-----------------------|-----------|----------|
| 110   | HAAS 4 Axis | 200 pcs |            | 1/10/20  | 0.01               | 6.69    | HAAS - 1              |           |          |
|       |             |         |            |          |                    |         | HAAS - 2              |           |          |
|       |             |         |            |          |                    |         | HAAS - 3              |           |          |
|       |             |         |            |          |                    |         | HAAS - 4              |           |          |
| 120   | QC 2        | 200 pcs |            | 1/10/20  | 0.00               | 0.00    | QC 2 - 1              |           |          |
|       |             |         |            |          |                    |         | QC 2 - 12             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 14             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 17             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 19             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 2              |           |          |
|       |             |         |            |          |                    |         | QC 2 - 20             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 22             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 23             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 25             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 32             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 33             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 35             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 39             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 4              |           |          |
|       |             |         |            |          |                    |         | QC 2 - 40             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 44             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 45             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 48             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 49             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 50             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 51             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 52             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 57             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 62             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 63             |           |          |
|       |             |         |            |          |                    |         | QC 2 - 8              |           |          |



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Container No: S244771



Part: D3601-1  
Job No: 204307  
Serial No/Batch: S244771

Revision:  
Inspector:  
Exp Date:  
Instructions: Various STC's

Date: 01/05/20

Plex 12/6/19 8:43 AM Dart.Renwick.Jennife

https://www.plexonline.com/dd9a4556-a5e9-4bee-8dae-dd1905278db0/Plexus\_Control/Report\_Viewer\_2.asp?URL=https://www.plexonline.com/dd9a... 1/5

|                                   |            |         |           |                                            |               |
|-----------------------------------|------------|---------|-----------|--------------------------------------------|---------------|
| 130 QC 8                          | 200<br>pcs | 1/10/20 | 0.00 0.00 | QC 2 - 66                                  |               |
|                                   |            |         |           | QC 2 - 64                                  |               |
|                                   |            |         |           | QC 2 - 65                                  |               |
|                                   |            |         |           | QC 2 - 5                                   |               |
|                                   |            |         |           | QC 2 - 71                                  |               |
|                                   |            |         |           | QC 2 - 73                                  |               |
|                                   |            |         |           | QC 2 - 69                                  |               |
|                                   |            |         |           | QC 8 - 12                                  | 20/01/05      |
|                                   |            |         |           | QC 8 - 14                                  |               |
|                                   |            |         |           | QC 8 - 17                                  |               |
|                                   |            |         |           | QC 8 - 20                                  |               |
|                                   |            |         |           | QC 8 - 25                                  |               |
|                                   |            |         |           | QC 8 - 3                                   |               |
|                                   |            |         |           | QC 8 - 32                                  |               |
|                                   |            |         |           | QC 8 - 33                                  |               |
|                                   |            |         |           | QC 8 - 35                                  |               |
|                                   |            |         |           | QC 8 - 39                                  |               |
|                                   |            |         |           | QC 8 - 4                                   |               |
|                                   |            |         |           | QC 8 - 44                                  |               |
|                                   |            |         |           | QC 8 - 45                                  |               |
|                                   |            |         |           | QC 8 - 49                                  |               |
|                                   |            |         |           | QC 8 - 58                                  |               |
|                                   |            |         |           | QC 8 - 8                                   |               |
|                                   |            |         |           | QC 8 - 9                                   |               |
|                                   |            |         |           | QC 8 - 68                                  |               |
|                                   |            |         |           | QC 8 - 67                                  |               |
| QC 8 - 1 (A)                      |            |         |           |                                            |               |
| QC 8 - 47                         |            |         |           |                                            |               |
| QC 8 - 40                         |            |         |           |                                            |               |
| QC 8 - 52                         |            |         |           |                                            |               |
| QC 8 - 23                         |            |         |           |                                            |               |
| QC 8 - 57                         |            |         |           |                                            |               |
| QC 8 - 76                         |            |         |           |                                            |               |
| QC 8 - 61                         |            |         |           |                                            |               |
| 140 Small Fab - 2 - B4B           | 200<br>pcs | 1/10/20 | 0.00 1.39 | Small Fab - 1 - B4B                        |               |
|                                   |            |         |           | Small Fab - 2 - B4B                        |               |
|                                   |            |         |           | Small Fab - 3 - B4B                        |               |
|                                   |            |         |           | Small Fab - 4 - B4B                        |               |
|                                   |            |         |           | Small Fab - 5 - B4B                        |               |
|                                   |            |         |           | Small Fab - 6 - B4B                        |               |
|                                   |            |         |           | Small Fab - 7 - B4B                        |               |
|                                   |            |         |           | Small Fab - 8 - B4B                        | 20/01/06      |
|                                   |            |         |           | Small Fab - 9 - B4B                        |               |
| 150 Handfinish - 1-1 Chemical-B4B | 200<br>pcs | 1/10/20 | 0.00 0.89 | Handfinish - 1 - 1 - B4B                   |               |
|                                   |            |         |           | Handfinish - 1 - 2 - B4B                   |               |
|                                   |            |         |           | Handfinish - 1 - 3 - B4B                   | 1 JAN 06 2020 |
|                                   |            |         |           | Handfinish - 1 - 4 - B4B                   |               |
|                                   |            |         |           | Handfinish - 1 - 5 - B4B                   |               |
|                                   |            |         |           | Handfinish - 1 - 6 - B4B                   |               |
|                                   |            |         |           | Handfinish - 1 - 7 - B4B                   |               |
|                                   |            |         |           | Handfinish - 1 - 8 - B4B                   |               |
|                                   |            |         |           | Handfinish - 1 - 9 - B4B                   |               |
|                                   |            |         |           | Plex 12/6/19 8:43 AM Dart.Renwick.Jennifer |               |

|                                 |         |         |      |      |                           |  |
|---------------------------------|---------|---------|------|------|---------------------------|--|
|                                 |         |         |      |      | Handfinish - 1 - 10 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 11 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 12 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 13 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 14 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 15 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 16 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 17 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 18 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 19 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 20 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 21 - B4B |  |
|                                 |         |         |      |      | Handfinish - 1 - 22 - B4B |  |
|                                 |         |         |      |      | QC 7 - 10                 |  |
| 160 QC 7                        | 200 pcs | 1/10/20 | 0.00 | 0.00 | QC 7 - 13                 |  |
|                                 |         |         |      |      | QC 7 - 14                 |  |
|                                 |         |         |      |      | QC 7 - 15                 |  |
|                                 |         |         |      |      | QC 7 - 17                 |  |
|                                 |         |         |      |      | QC 7 - 18                 |  |
|                                 |         |         |      |      | QC 7 - 19                 |  |
|                                 |         |         |      |      | QC 7 - 2                  |  |
|                                 |         |         |      |      | QC 7 - 28                 |  |
|                                 |         |         |      |      | QC 7 - 3                  |  |
|                                 |         |         |      |      | QC 7 - 30                 |  |
|                                 |         |         |      |      | QC 7 - 34                 |  |
|                                 |         |         |      |      | QC 7 - 36                 |  |
|                                 |         |         |      |      | QC 7 - 37                 |  |
|                                 |         |         |      |      | QC 7 - 41                 |  |
|                                 |         |         |      |      | QC 7 - 47                 |  |
|                                 |         |         |      |      | QC 7 - 48                 |  |
|                                 |         |         |      |      | QC 7 - 51                 |  |
|                                 |         |         |      |      | QC 7 - 58                 |  |
|                                 |         |         |      |      | QC 7 - 59                 |  |
|                                 |         |         |      |      | QC 7 - 60                 |  |
|                                 |         |         |      |      | QC 7 - 9                  |  |
|                                 |         |         |      |      | QC 7 - 68                 |  |
|                                 |         |         |      |      | QC 7 - 50                 |  |
|                                 |         |         |      |      | QC 7 - 67                 |  |
|                                 |         |         |      |      | QC 7 - 40                 |  |
|                                 |         |         |      |      | QC 7 - 24                 |  |
|                                 |         |         |      |      | QC 7 - 43                 |  |
|                                 |         |         |      |      | QC 7 - 61                 |  |
|                                 |         |         |      |      | QC 7 - 81                 |  |
|                                 |         |         |      |      | QC 7 - 76                 |  |
|                                 |         |         |      |      | QC 7 - 79                 |  |
| 170 Packaging 3-1 - Stock - B4B | 200 pcs | 1/10/20 | 0.00 | 0.00 | Packaging 3 - 1 - B4B     |  |
|                                 |         |         |      |      | Packaging 3 - 2 - B4B     |  |
|                                 |         |         |      |      | Packaging 3 - 3 - B4B     |  |

DAE  
40  
9-89  
JAN 0 6 2020

DAS  
82  
9-89

DAS  
74  
9-8

51042 JAN 06 2020

|                        |  |
|------------------------|--|
| Packaging 3 - 4 - B4B  |  |
| Packaging 3 - 5 - B4B  |  |
| Packaging 3 - 6 - B4B  |  |
| Packaging 3 - 7 - B4B  |  |
| Packaging 3 - 8 - B4B  |  |
| Packaging 3 - 9 - B4B  |  |
| Packaging 3 - 10 - B4B |  |
| Packaging 3 - 11 - B4B |  |
| Packaging 3 - 12 - B4B |  |
| Packaging 3 - 13 - B4B |  |
| Packaging 3 - 14 - B4B |  |
| Packaging 3 - 15 - B4B |  |
| Packaging 3 - 16 - B4B |  |
| Packaging 3 - 17 - B4B |  |
| Packaging 3 - 18 - B4B |  |
| Packaging 3 - 19 - B4B |  |
| Packaging 3 - 20 - B4B |  |
| Packaging 3 - 21 - B4B |  |
| Packaging 3 - 22 - B4B |  |
| Packaging 3 - 23 - B4B |  |
| Packaging 3 - 24 - B4B |  |
| Packaging 3 - 25 - B4B |  |
| Packaging 3 - 26 - B4B |  |
| Packaging 3 - 27 - B4B |  |
| Packaging 3 - 28 - B4B |  |
| Packaging 3 - 29 - B4B |  |
| Packaging 3 - 30 - B4B |  |
| Packaging 3 - 31 - B4B |  |
| Packaging 3 - 32 - B4B |  |
| Packaging 3 - 33 - B4B |  |
| Packaging 3 - 34 - B4B |  |
| Packaging 3 - 35 - B4B |  |
| Packaging 3 - 36 - B4B |  |

180 QC 21 - SA 200 1/10/20 0.00 0.00 pcs

|                 |      |
|-----------------|------|
| QC 21 - SA - 21 | DAS  |
| QC 21 - SA - 70 | 21   |
| QC 21 - SA - 53 | 9-50 |

JAN 06 2020

Part Op 110 - (HAAS CNC Vertical Machine) Cut blanks 9.00" long +/- 0.030" Note: 1 blank makes 8 pieces 1-Min as per File  
Descriptions: FA682 Rev: AA & Dwg D3601 Rev: A

- 120 - (QC2- Inspect parts off machine FAI/FAIB)
- 130 - (QC8- Inspect parts - second check)
- 140 - (Small Fab) 1-Tumble 2-Deburr any rough edges after tumbling
- 150 - (Chemical Conversion Coat per QSI005 4.1)
- 160 - (QC7-Inspect Chemical Conversion Coat)
- 170 - (Identify as per dwg & Stock Location:\_\_\_\_\_)
- 180 - (QC21- Final Inspection - Work Order Release)

Used  
18.75

| Job BOM              |                         |                      |                 |           |
|----------------------|-------------------------|----------------------|-----------------|-----------|
| Part / Item          | Component Name          | Quantity             | Operation       | Container |
| M6061T6B0.750X00.125 | 6061-T6 Bar .750 X .125 | 18.8000 ft (.094 ea) | 110-HAAS 4 Axis | 5166897   |

| Job Allocations |                      |          |           |           |
|-----------------|----------------------|----------|-----------|-----------|
| Operation       | Component Part       | Required | Inventory | Allocated |
| 110-HAAS 4 Axis | M6061T6B0.750X00.125 | 19       | 103       | 0         |

| Part Specifications                |  |  |  |  |
|------------------------------------|--|--|--|--|
| Specifications could not be found. |  |  |  |  |

Plex 12/6/19 8:43 AM Dart.Renwick.Jennifer

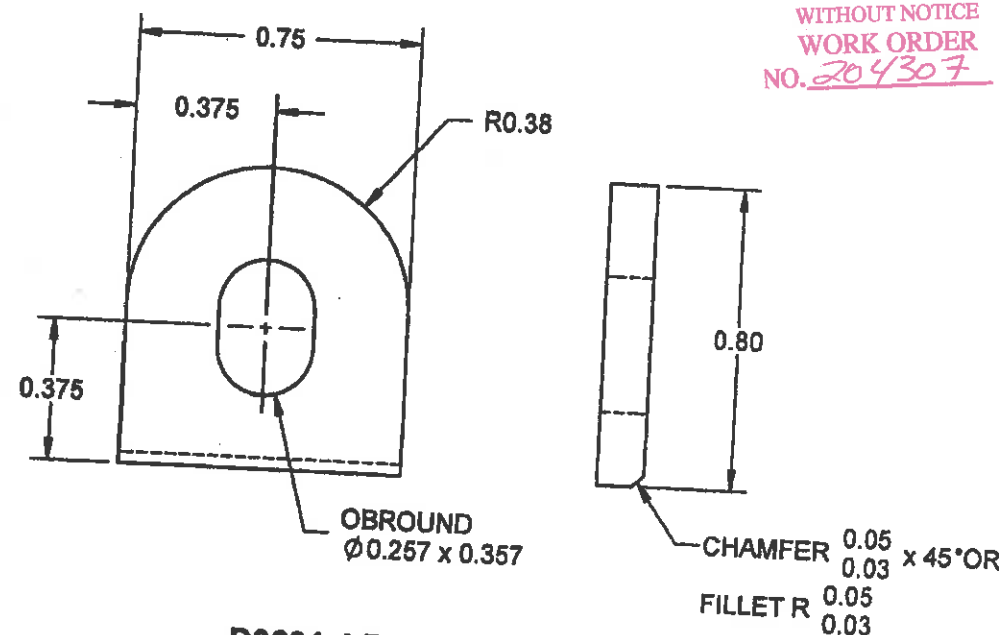


|                               |                                |                                                          |                        |
|-------------------------------|--------------------------------|----------------------------------------------------------|------------------------|
| DESIGN<br><b>CB</b>           | DRAWN BY<br><b>CB</b>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><b>[Signature]</b> | APPROVED<br><b>[Signature]</b> | DRAWING NO.<br><b>D3601</b>                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br><b>07.02.13</b>       |                                | TITLE<br><b>RADIUS BLOCK</b><br>SCALE<br>2:1             |                        |
| REV<br><b>A</b>               | DATE<br><b>07.02.13</b>        | DESCRIPTION<br><b>NEW ISSUE</b>                          |                        |

RELEASED  
07.03.08 **[Signature]**



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 204307



**D3601-1 RADIUS BLOCK**

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016  
(REF DART SPEC M5052H32S.125) OR  
ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027  
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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|                                  |  |                              |  |                |  |                                     |  |                                      |  |                                                           |  |                                                 |  |  |  |
|----------------------------------|--|------------------------------|--|----------------|--|-------------------------------------|--|--------------------------------------|--|-----------------------------------------------------------|--|-------------------------------------------------|--|--|--|
| NCR No. _____                    |  |                              |  |                |  |                                     |  |                                      |  |                                                           |  |                                                 |  |  |  |
| Job: _____                       |  | DISPOSITION                  |  |                |  | DEPARTMENT/PROCESS                  |  |                                      |  |                                                           |  |                                                 |  |  |  |
| Part No. _____                   |  | Rework<br>Scrap<br>Use-as-is |  |                |  | Skid-tube<br>Machining<br>Large Fab |  | Cross tube<br>Small Fab<br>Finishing |  | Eng. (Non-AW)<br>Prod. Eng. Coord.<br>Rec/Store/Packaging |  | Engineering<br>Water Jet<br>Supplier<br>Quality |  |  |  |
| Date : _____                     |  | Sequence #:                  |  | QTY Affected : |  | MRB (QSI042)                        |  |                                      |  |                                                           |  |                                                 |  |  |  |
| Description Work Order Deviation |  |                              |  |                |  |                                     |  |                                      |  |                                                           |  | Disposition                                     |  |  |  |
|                                  |  |                              |  |                |  |                                     |  |                                      |  |                                                           |  |                                                 |  |  |  |
|                                  |  |                              |  |                |  |                                     |  |                                      |  |                                                           |  |                                                 |  |  |  |
|                                  |  |                              |  |                |  |                                     |  |                                      |  |                                                           |  |                                                 |  |  |  |
|                                  |  |                              |  |                |  |                                     |  |                                      |  |                                                           |  |                                                 |  |  |  |
| Root Cause                       |  |                              |  |                |  | FAULT CATEGORY                      |  |                                      |  |                                                           |  |                                                 |  |  |  |
| Operator                         |  |                              |  |                |  | Pressure/Forced                     |  | Contamination                        |  | Power Loss/Surge                                          |  | Positioned Wrong                                |  |  |  |
| Manufacturing Process            |  |                              |  |                |  | Bending                             |  | Misaligned/off center                |  | Folio/Program                                             |  | Outside Tolerance                               |  |  |  |
| Equip/Tooling                    |  |                              |  |                |  | Crushing                            |  | BOM/Route                            |  | Grain Direction                                           |  | Drawing                                         |  |  |  |
| Handling/Preservation            |  |                              |  |                |  | Cracks                              |  | Broken/Damage/Defect                 |  | Weld                                                      |  | Finish                                          |  |  |  |
| Material                         |  |                              |  |                |  | Crimp/Kink/Ripple/Wave/Twist        |  | Incomplete/Unclear Instructions      |  | Wrong Stock Pulled                                        |  | Part Lost/Missing                               |  |  |  |
| Product Improvement              |  |                              |  |                |  | Marks/Chatter                       |  | Drill Holes                          |  | Out of Sequence                                           |  | Misread                                         |  |  |  |
| Process Improvement              |  |                              |  |                |  | Mislabeled                          |  | Fit/Function                         |  | Off-set/Set-up                                            |  |                                                 |  |  |  |
| Human Factors                    |  |                              |  |                |  | Other/Details:                      |  |                                      |  |                                                           |  |                                                 |  |  |  |